

Work Order ID 53088

October 22, 2009 3:52:43 PM



Page 1

Item ID:	D3159-044	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Bracket Assembly					
Start Date:	21/10/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>RL</u>	Date:	<u>09-10-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS CNC VERTICAL MACHINING #1	0.00							
	Memo								
	Machine as per Folio FA238								
105	Water Jet								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
	Memo								
	Quality Control								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
	Memo								
	Quality Control								

B 9-11-5

(15)

B 9-11-5

2) 8 or 105

(415) f

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Item ID: D3159-044
Revision ID: C
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr break all sharp edges .005 to 0.010 □ 2-C'sink holes as per Dwg D3159

Deburr = 7 m-h 09/11/05 (15x)

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per drawing (Note: -044 OPPOSITE)

SP 09/11/09

09/11/06 (15)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

09/11/10

(XL5)

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Setup Start



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Required Date: 04/11/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg.								
170 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
180 Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							

E 509/11/10 (15)

SB 09/11/11

15

9/11/11 (15)

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Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 4.00
Required Date: 04/11/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
 QC	Memo	0.00							
Quality Control									

09/11/11
MF
09-11-11

Picklist Print

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Work Order ID: 53088

Parent Item: D3159-044RevC

Parent Item Name: Bracket Assembly

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-4 RIVET		Purchased	No			100	Each	7,861.000	8.0000			

M 7681 (300)

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7861	
104374	3861	
110398	4000	

09/11/10

M6061T6S.063

Purchased

No

160

sf

233.2841

0.1217

15000

B9-11-5

6061-T6 .063 Sheet

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	233.2841211	
110551	33.2841211	
112939	200	

110551

MS21061L06

Purchased

No

160

Each

129.0000

4.0000

09/11/10

Nutplate

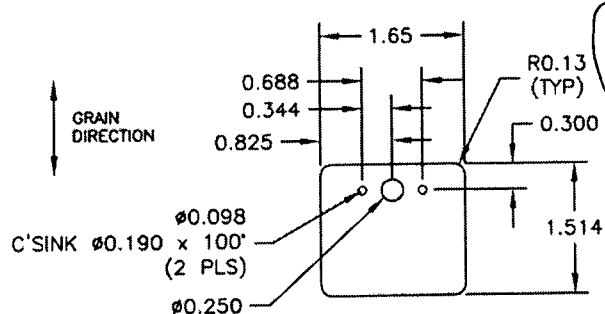
Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	129	
19085	29	
19185	100	

15

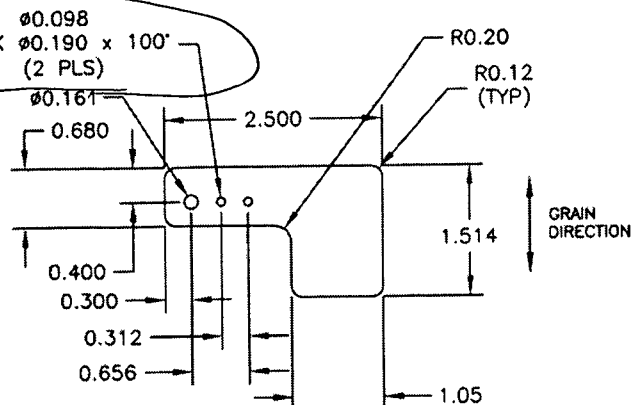
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53088

DART 07-10-27

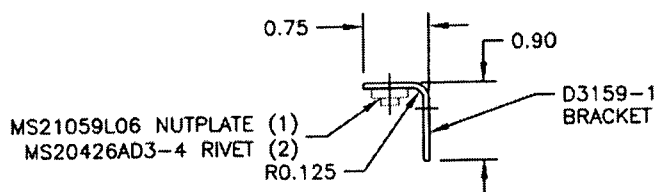
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3159	REV. C SHEET 1 OF 1
DATE 05.11.21	TITLE BRACKET ASSEMBLY		SCALE 1:2
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.11.21	CORRECT VIEW	



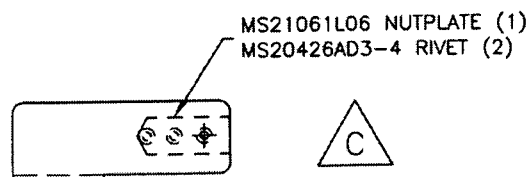
D3159-1F FLAT PATTERN
(USED TO MAKE D3159-1 BRACKET)



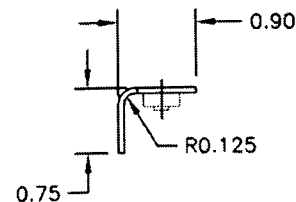
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3159-041 BRACKET ASSEMBLY



D3159-3/-4
BRACKET



D3159-043 BRACKET ASSEMBLY (SHOWN).
REPLACES PREMIER P/N B30-23000-259
(D3159-044 BRACKET ASSEMBLY (OPPOSITE)).
REPLACES PREMIER P/N B30-23000-260)

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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